DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-008684
Date Inspected: 19-Aug-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai,China

CWI Name: Lv Li Qing / Shen Fu You

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Tim McClendon was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG Bay No. 14

This Quality Assurance Inspector (QA) observed that the contractor appears to have deviated from the weld joint design specified on the approved drawings. The contractor appears to have changed the weld joint from a Fillet Weld to a Complete Joint Penetration (CJP) weld with steel backing. This deviation was performed without the Engineers approval. According to the ZPMC QC inspector, the weld design was changed in order to compensate for a joint root opening in excess of 5mm. This condition exists in the following locations; OBG segment 9BE SEG 052C between PP074 and PP75 for weld joining Longitudinal Diaphragm LD004-041 to bottom panel BP125-001, weld numbers 026/027. See photographs for additional information. An incident report will be written on this issue.

Flux Cored Arc Welding (FCAW) on Bottom Panel to Side Panel Complete Joint Penetration weld of weld joint SEG 056A for OBG weld number 011 for Segment 9DE. The ZPMC welder identified as 055491 was welding in the 1G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2231-B-U2-F.

WELDING INSPECTION REPORT

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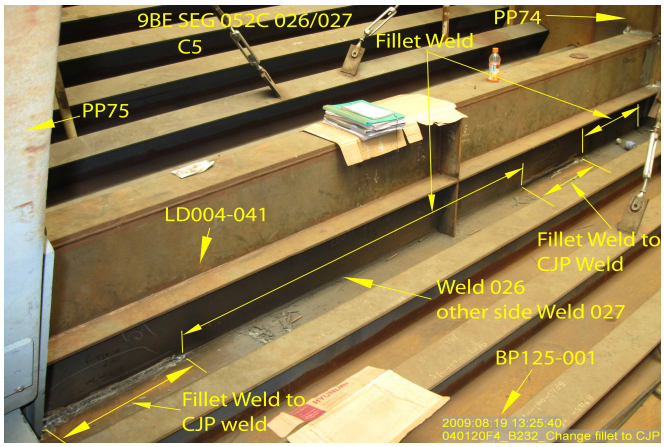
Flux Cored Arc Welding (FCAW) on Bottom Panel to Side Panel Complete Joint Penetration weld of weld joint SEG 056A for OBG weld number 020 for Segment 9DE. The ZPMC welder identified as 044795 was welding in the 1G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2231-B-U2-F.

Flux Cored Arc Welding (FCAW) on Longitudinal Diaphragm Fillet weld of weld joint SEG 052G for OBG weld number 015 for Segment 9BE. The ZPMC welder identified as 214945 was welding in the 2F position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations spoken on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	McClendon,Timothy	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer